Wednesday, 1/11/2006 4:21:05 PM

Kim Johnston

Process Sheet

Customer

: CU-DAR001 Dart Helicopters Services

Job Number

: 25441C

Estimate Number P.O. Number

: 10280

This Issue Prsht Rev. : N/A : 1/11/2006

: NC

NIA : 24267C

S.O. No. : N/A

Type

: MACHINED PARTS

Part Number Drawing Number

Drawing Name

: D3137043 : D3137 REV D'E

: BRACKET ASSEMBLY

Project Number

: N/A

Drawing Revision Material

Due Date

: DE

Each

Written By

First Issue

Previous Run

Checked & Approved By

Comment

: Est Rev:A 04.02.18 New issue KJ/DS

Additional Product

Job Number:



Seq. #:

1.0

Machine Or Operation:

Description:



17-4 SS Bar

Comment: Qty.: 0.4875 f(s)/Unit Total:

Material: 17-4 SS Bar per AMS 5604/5643

(M17-4-B0.500x02.000) Identify for D3121-113

Batch: M19572

2.0

BAND SAW

Comment: BAND SAW 0:500

Cut blanks: (4:000" x 2.000") 5.570" long

3.0

HAAS CNC VERTICAL MACHINING #



BAND SAW



Comment: HAAS CNC VERTICAL MACHINING #1

1-Machine D3137-7 as per Folio FA3308and Dwg D3137 Identify as D3137-7

2-Deburr

3-Scribe batch number

4.0

QC2

INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE





Dart A	Aerc	spa	ce	Ltd
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	WORK ORDER CHANGES								
STEP		PROCEDU	RE CHANGE		Ву	Date	Qty	Chief Eng /	Approval QC Inspector
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		<i>C</i>	; c c c c	STEP PROCEDURE CHANGE	STEP PROCEDURE CHANGE	STEP PROCEDURE CHANGE By	STEP PROCEDURE CHANGE By Date	STEP PROCEDURE CHANGE By Date Qty	STEP PROCEDURE CHANGE By Date Qty Chief Eng / Prod Mgr

Part No: _	7	PAR #:	Fault Category:	NCR: Yes No DQA:	Date:
	"			QA: N/C Closed:	Date:

NCR:	WORK ORDER NON-CONFORMANCE (NCR)							
		Description of NC		Corrective Action Section E		Verification	Approval Chief Eng Q	Annroyal
DATE STEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Section C	Approval QC Inspecto		
				·				
	-							
		_						

NOTE: Date & initial all entries

Wednesday, 1/11/2006 4:21:05 PM Date: Kim Johnston User: **Process Sheet Drawing Name: BRACKET ASSEMBLY** Customer: CU-DAR001 Dart Helicopters Services Job Number: 25441C Part Number: D3137043 Job Number: Description: Seq. #: **Machine Or Operation:** SECOND CHECK 5.0 MS Comment: SECOND CHECK 06/02/05 Guide D31373 6.0 1.0000 Each(s)/Unit Total: 4.0000 Each(s) Comment: Qty.: Pick: Qty Part Number Description Batch 1 D3137-3 GUIDE B 75012 7.0 D31375 Washer Comment: Qty.: 1.0000 Each(s)/Unit Total: 4.0000 Each(s) Pick: Description Batch **Qty Part Number** 1 D3137-5 Washer <u>824547</u> BG- 66.02-10 MS24694S101 8.0 1.0000 Each(s)/Unit Total: 4.0000 Éach(s) Comment: Qty.: Pick: Qty Part Number Description Batch 1 MS24694-s101 Screw 11694L SMALL & MEDIUM FAB RESOURCE 1 9.0 SMALL FAB 1 Comment: SMALL & MEDIUM FAB RESOURCE 1 Assemble D3137-043 as per Dwg D3137 30 INSPECT WORK TO CURRENT STEP 10.0 Comment: INSPECT WORK TO CURRENT STEP 36 PACKAGING 1 PACKAGING RESOURCE #1 11.0 Comment: PACKAGING RESOURCE #1 Identify and Stock C 206/02/10 Location: 409

Dart Aerospace Ltd

W/O: WORK ORDER CHANGES						*	
DATE	E STEP PROCEDURE CHANGE		Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
Part No	:	PAR #: Fault Category:	NCR: Yes	NoDQ	A: £	Date: _{	Soloali

QA: N/C Closed: ____ Date: ____

	WORK ORDER NON-CONFORMANCE (NCR)							
	Description of NC	Corrective Action Section B			Varification	Annessal	A	
STEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Section C	Chief Eng	Approval QC Inspector	
				į				
	STEP	STED Description of NC	STEP Description of NC Section A Initial	STEP Description of NC Corrective Action Section B Initial Action Description	STEP Description of NC Section A Initial Action Description Sign &	STEP Section A Initial Action Description Sign & Section C	STEP Description of NC Section A Initial Action Description Sign & Verification Section C Chief Eng	

NOTE: Date & initial all entries

Date: User: ्

Wednesday, 1/11/2006 4:21:05 PM

Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: BRACKET ASSEMBLY

Job Number: 25441C

Part Number: D3137043

Job Number:



Seq. #:

Machine Or Operation:

Description:

12.0

DOCUMENT CONTROL

Comment: DOCUMENT CONTROL

Inspection Level 21

0160/00 R

Job Completion



U 06-02-10

Dart Ae	rospace L	.td							
W/O:			WC	ORK ORDER CHANGES					
DATE STEP		PR	OCEDURE CHA	NGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
								· · · · · · · · · · · · · · · · · · ·	
Part No		PAR #:	Fault Cate	gory: N	CR: Yes	No DQA:	·	_ Date: _	
					QA: N	/C Closed:		_ Date: _	
NCR:			WORK ORD	ER NON-CONFORMANC	CE (NCR	R)			
DATE	CTED	Description of NC		Corrective Action Section B	Verification App			Approval	Approval
DATE	STEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Section		Chief Eng	QC Inspector
							į		
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NOTE: Date & initial all entries



DESIG	n DS	DRAWN BY RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA
CHECH	(ED	APPROVED #	DRAWING NO. REV. E D3137 SHEET 1 OF 5
DATE		· · · · · · · · · · · · · · · · · · ·	TITLE SCALE
05.1	1.23		BRACKET ASSEMBLY 1:1
Α		02.04.17	NEW ISSUE
В		03.01.16	ADD RIDGES; ADD MAT'L PROP.
С		03.08.15	ADD -043
D		04.11.03	RE-DESIGN D3137-5; CHANGE DIMS
E		05.11.23	ADD -045

RELEASE 05-12-09

> MS24694-S101 SCREW D3137-5 WASHER D3137-3 GUIDE INSTALL ON SAME SIDE AS C'SINKS (OPPOSITE SIDE FROM RIDGES)

D3137-1 BRACKET (-041 SHOWN) D3137-7 BRACKET (-043 SIMILAR) OR D3137-9 BRACKET (-045 SIMILAR)

D3137-041 BRACKET ASSEMBLY (SHOWN) D3137-043 BRACKET ASSEMBLY (SIMILAR)

SHOP COPY

RETURN TO **ENGINTERING**

UNCONTROLLED COPY

SUC. IT TO AMENDMENT WITH ICUT NOTICE

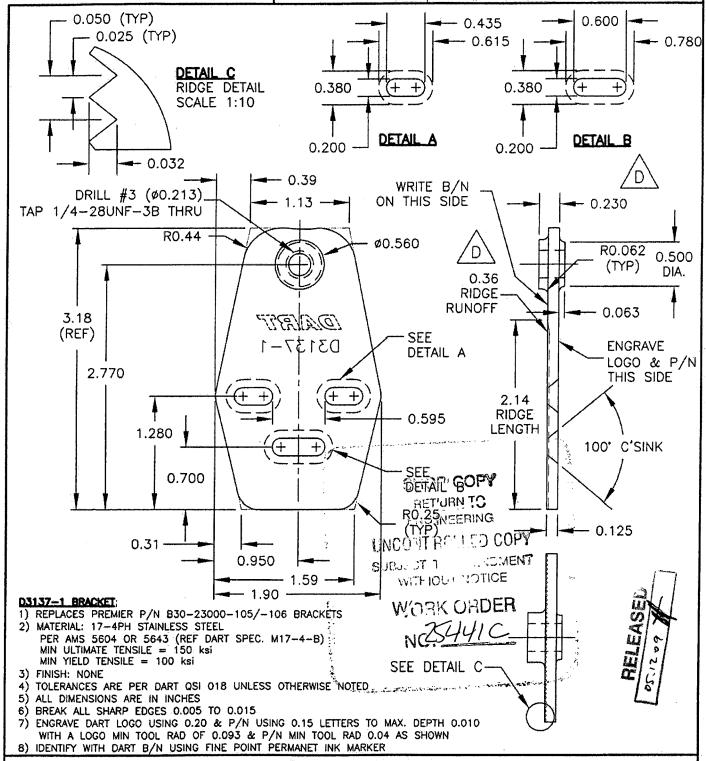
WORK ORDER NO. 25441C

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DESIGN D5	DRAWN BY	DART AEROS HAWKESBURY, ONT	
CHECKED	APPROVED #	DRAWING NO.	REV. E SHEET 2 OF 5
DATE		TITLE	SCALE
05.11.23		BRACKET ASSEMBLY	. 1:1

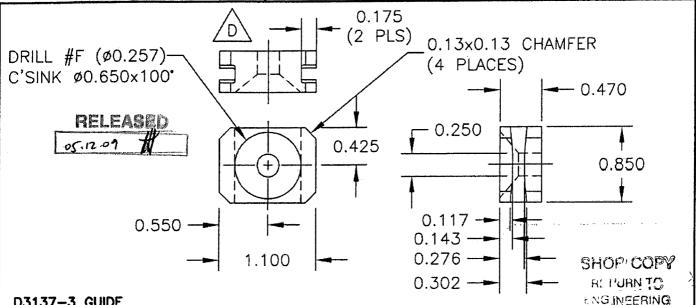


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design DS	DRAWN BY RF	DART AEROSP HAWKESBURY, ONTAR	
CHECKED	APPROVED	DRAWING NO.	REV. E
- M		D3137	SHEET 3 OF 5
DATE		TITLE	SCALE
05.11.23		BRACKET ASSEMBLY	1:1



D3137-3 GUIDE

- 1) REPLACES PREMIER P/N B30-23000-207
- 2) MATERIAL: DELRIN BAR (REF DART SPEC. M-DELRIN-B)
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL EDGES 0.005 TO 0.015

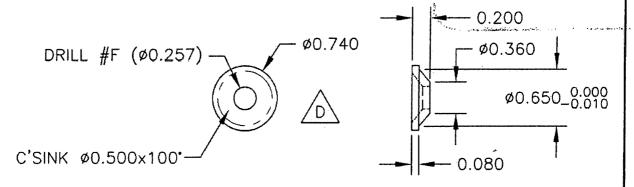
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WORK ORDER NO. 254410



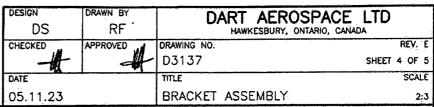
D3137-5 WASHER

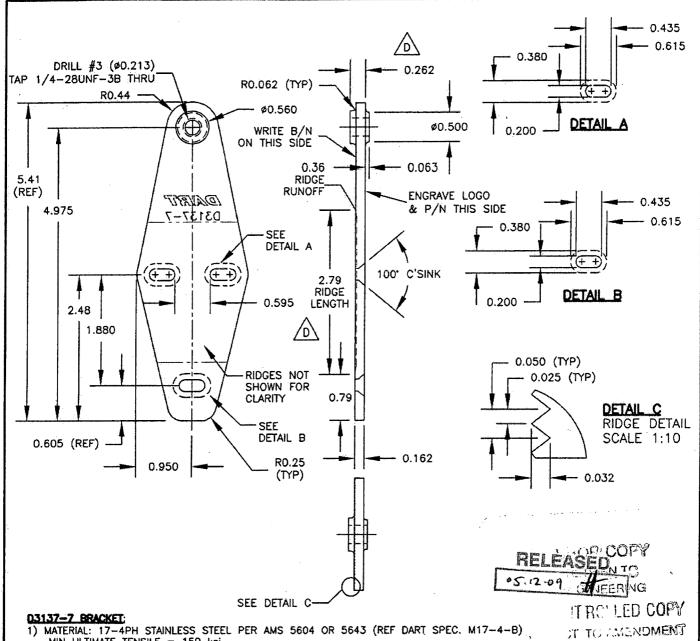
- 1) REPLACES PREMIER P/N B30-23000-209
- 2) MATERIAL: 6061-T6 (QQ-A-225/8 OR QQ-A-200/8) BAR (REF DART SPEC. M6061T6R)
- 3) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) BREAK ALL EDGES 0.005 TO 0.015

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1) MATERIAL: 17-4PH STAINLESS STEEL PER AMS 5604 OR 5643 (REF DART SPEC. M17-4-B) MIN ULTIMATE TENSILE = 150 ksi MIN YIELD TENSILE = 100 ksi

THOUT NOTICE

2) FINISH: NONE

3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

WORK ORDER

4) ALL DIMENSIONS ARE IN INCHES

5) BREAK ALL SHARP EDGES 0.005 TO 0.015

ENGRAVE DART LOGO USING 0.20 & P/N USING 0.15 LETTERS TO MAX. DEPTH 0.010 WITH A LOGO MIN TOOL RAD OF 0.093 & P/N MIN TOOL RAD 0.04 AS SHOWN

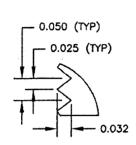
7) IDENTIFY WITH DART B/N USING FINE POINT PERMANENT INK MARKER

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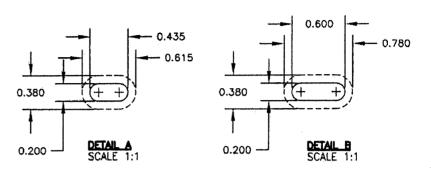
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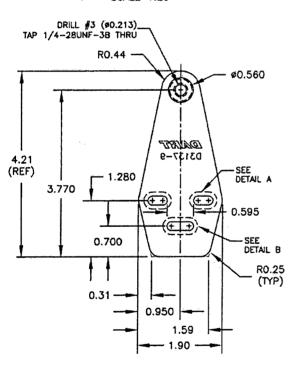


DESIGN DS	DRAWN BY RF	DART AEROSI HAWKESBURY, ONTA	
CHECKED	APPROVED	DRAWING NO.	REV. E
94	714	D3137	SHEET 5 OF 5
DATE	-	TITLE	SCALE
05.11.23		BRACKET ASSEMBLY	1:2



DETAIL C RIDGE DETAIL SCALE 1:20



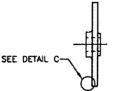


RO.062 DIA. (TYP) WRITE B/N ON THIS SIDE 0.063 **FNGRAVE** RIDGE LOGO & P/N THIS SIDE 2.14 RIDGE , JP COFY LENGTH 100° C'SINK THURN TO HING INFERING TRO: LED CO 0.162 OT TO A LOMINT WITH IOUT NOTICE WORK ORDER

0.262

0.500

RELEASED



03137-9 BRACKET: 1) REPLACES PREMIER P/N 830-23000-105/-106 BRACKETS

2) MATERIAL: 17-4PH STAINLESS STEEL PER ANS 5604 OR 5643 (REF DART SPEC. M17-4-8)
MIN ULTIMATE TENSILE = 150 ksi
MIN YIELD TENSILE = 100 ksi

- 3) FINISH: NONE
- TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- ALL DIMENSIONS ARE IN INCHES BREAK ALL SHARP EDGES 0.005 TO 0.015
- 7) ENGRAVE DART LOGO USING 0.20 & P/N USING 0.15 LETTERS TO MAX. DEPTH 0.010
 WITH A LOGO MIN TOOL RAD OF 0.093 & P/N MIN TOOL RAD 0.04 AS SHOWN
 8) IDENTIFY WITH DART B/N USING FINE POINT PERMANENT INK MARKER

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DART AEROS	SPACE LTD				Work Order	25441 C M
Description:					Part Number	: 3137-7
Inspection Dwg:	Inspection Dwg: Rev:					Page 1 of 1
	FIRST	ABTICLE IN	SPECTION	ON CHE	CKLIST	
	. /	First Artic	le	Proto	otype	
Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
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	100					
	·				42	
	1			58/	100	
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Measured by:	42	Audited by:	P	ototype .	Approval:	
Date:	06.0202	Date:			Date:	
Rev Date	Change				Revised by	Approved
	New Issue				KJ/RE	

Revised by KJ/RF